

5/42

Split

DART AEROSPACE LTD	Work Order:	24407 B
Description: Lug Clamp <i>PC 01-08-07</i>	Part Number:	D3041-3
Drawing: D3041 Rev. A I	Qty:	40

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	FF	05.10.04	40
2	METAL	Cut blanks: 1.250 long Material: D2423 Lug extrusion			
3	HAAS <i>PG</i>	Machine per folio FA153 <i>Issue P.O. 2008788</i> <i>Batch: B21202</i> Check for crack while loading into the machine	<i>ML</i>	<i>05/10/06</i>	<i>43</i>
4	<i>QC PG</i>	Inspect Level 2 <i>Receive + Inspect for least damage</i>	<i>CU</i>	<i>05-10-12</i>	<i>43</i>
5	QC	Inspect Level 2	<i>CU</i>	<i>05/11/25</i>	<i>40</i>
6	METAL	Tumble and deburr <i>if applicable</i> rough edges after tumbling	<i>2</i>	<i>05.11.28</i>	<i>40</i>
7	METAL	Acid etch and Alodine per QSI 005 4.1	<i>FF</i>	<i>05.11.29</i>	<i>40</i>
8	METAL	Inspect Level 5	<i>FF</i>	<i>05.11.30</i>	<i>40</i>
9	FINISHING	Mask inside of 0.8120" dia. Hole	<i>ML</i>	<i>05 11 30</i>	<i>40</i>
10	FINISHING	Powder Coat White (ref. 4.3.5.1) per QSI 005 4.3	<i>ML</i>	<i>05 11 30</i>	<i>40</i>
11	QC	Pick: Qty Part number Description batch 1 D2611 Bearing <i>10 B24461</i> <i>B 24769 40 D15886</i>	<i>SB</i>	<i>05/12/14</i>	<i>20</i>
12	QC	Press D2611 bearing into lug as per dwg D3041	<i>SB</i>	<i>05/12/14</i>	<i>20</i>
13	QC	Stake bearing into place as per dwg D3041	<i>SB</i>	<i>05/12/14</i>	<i>20</i>
14	QC	Inspect Level 7	<i>2</i>	<i>05-12-14</i>	<i>20</i>
15	STORES	Identify and stock	<i>Luc 133</i>	<i>05/12/14</i>	<i>20</i>
16	EXPEDITING	Close W/O Job Cost / Part <i>545 05/12/15</i>	<i>20</i>	<i>05/12/15</i>	<i>20</i>

Rev	Date	Change	Revised By	Approved
A	01.07.11	New Issue	SM	<i>EC</i>

RELEASED

EC 01.07.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

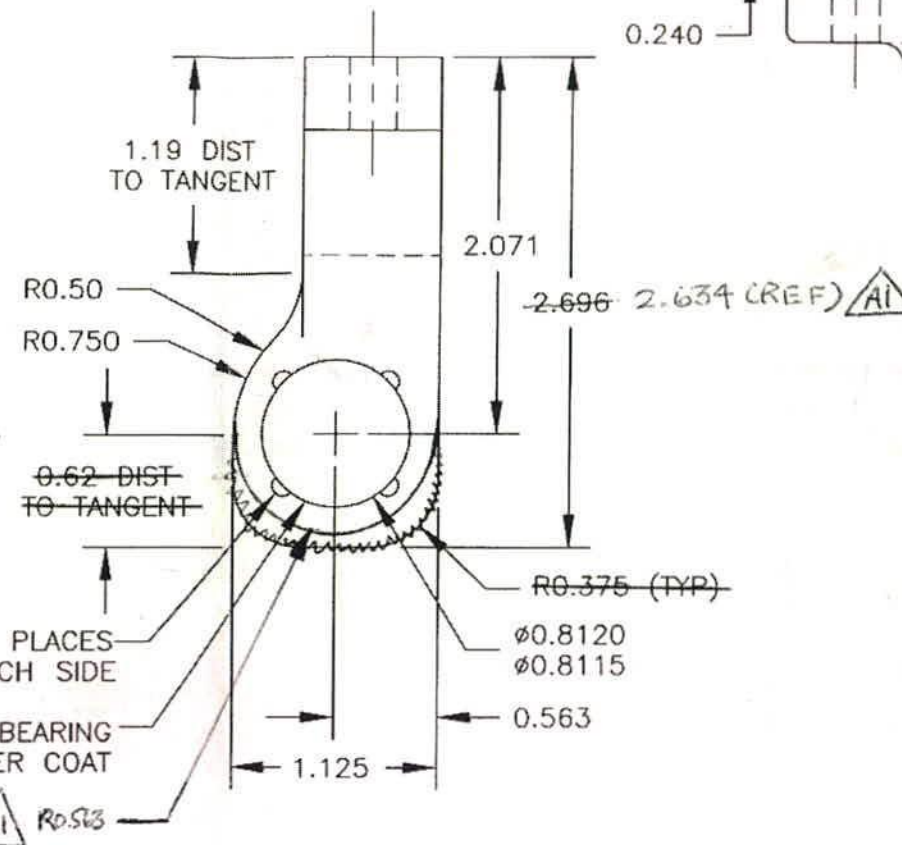
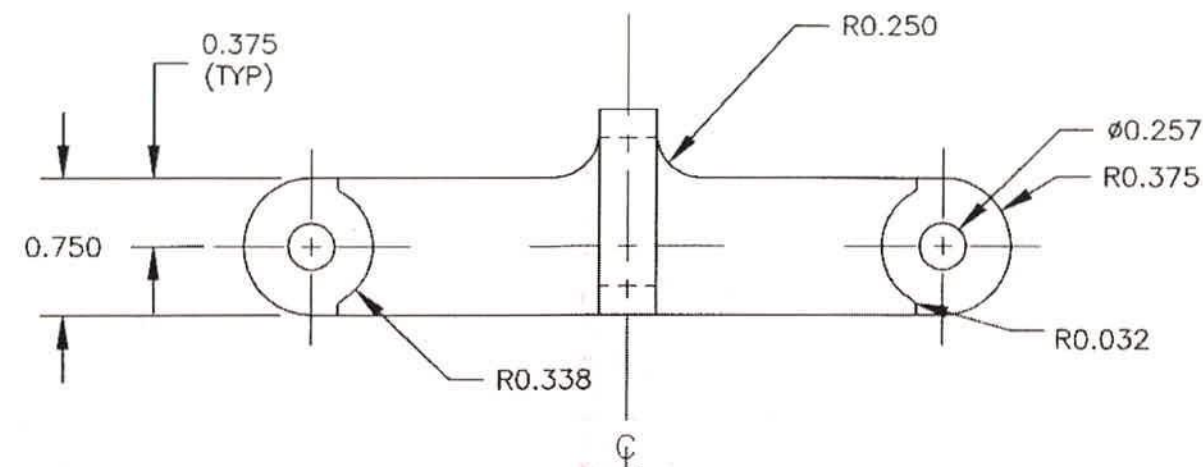
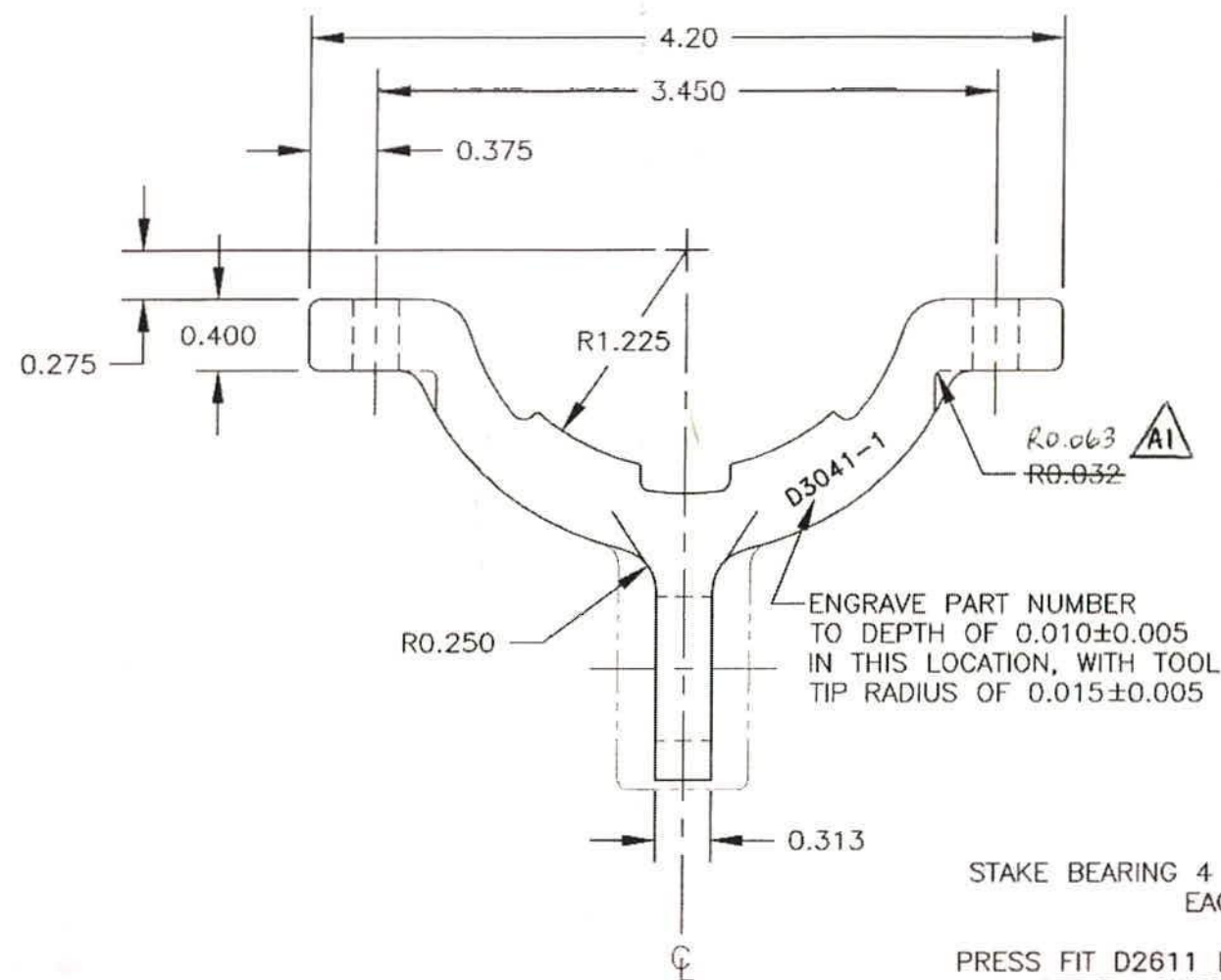
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PD Date: 05/12/15

NOTE: Date & initial all entries

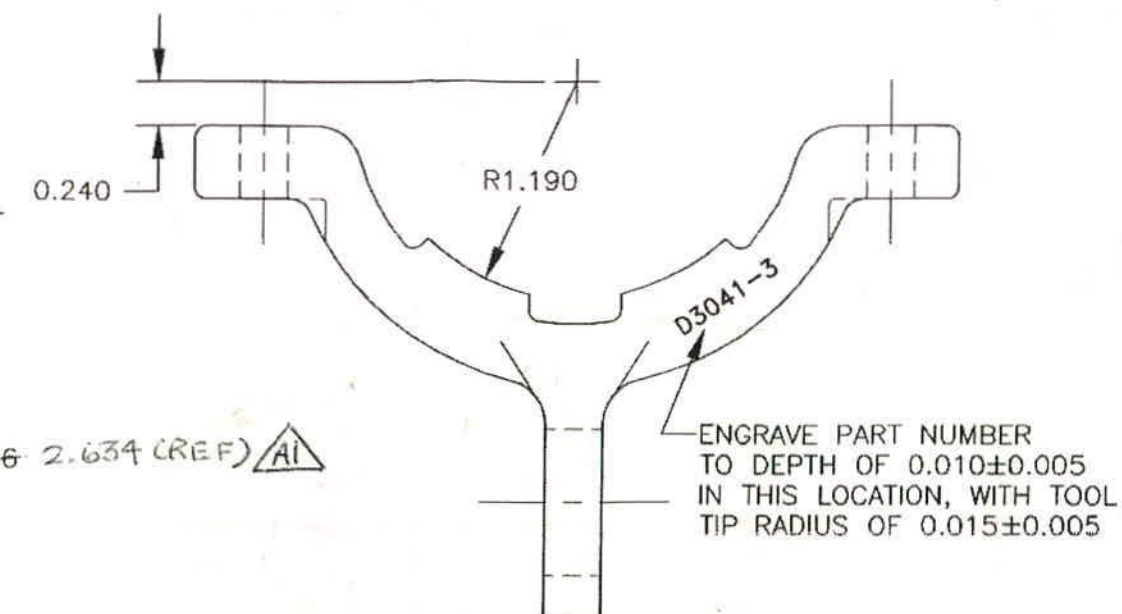
QA: N/C Closed: _____ Date: _____

D3041-1



D3041-3

SAME AS D3041-1 EXCEPT AS SHOWN



RELEASED

SHOP COPY

UNDER REVIEW

UNCONTROLLED COPY

SUBJECT TO AGREEMENT

WITHOUT NOTICE

WORK ORDER

NO. 24407

D3041-1 & D3041-3 CLAMPS

- 1) MANUFACTURE FROM EXTRUSION D2423
- 2) PART IS SYMMETRIC ABOUT CENTERLINE
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 5) STAKE D2611 BEARING AFTER POWDER COAT
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A	01.06.28	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	#	APPROVED
DATE	01.06.28	TITLE
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DRAWING NO. D3041		REV. A
TITLE CLAMP		SHEET 1 OF 1
		SCALE 1:1

CHANGE TO ROUND END DETAIL
R0.063 WAS R0.032

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 03, 2005
11:23 am

Work Order No : 0024407
Project Name : D3041-3
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3041-3
Description : Clamp
Manufactured : Yes
Amount Req'd : 40
Amount Done : 0
Start Date : 10-03-05
Est Finish Date : 10-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:07 pm

Work Order No : 0024407
Project Name : D3041-3
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3041-3
Description : Clamp
Manufactured : Yes
Amount Req'd : 40
Amount Done : 0
Start Date : 10-03-05
Est Finish Date : 10-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	1.50	100.00		
Production Cost :	0.00	30.86	100.00	0.00	30.86
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	1.50	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	30.86	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	30.86			

Labour Hrs/Amount Done :	Estimated	Actual
Profits/(Loss) :	0.00	0.00
	0.00	(-30.86)

Mis o/B
~
11.13

Date: Monday, 14/11/2005 8:22:12 AM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 24407		
Estimate Number	: 10351		
P.O. Number	:	Part Number	: D30413
This Issue	: 14/11/2005 S.O. No. :	Drawing Number	: D3041 REV. A1
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	:	Material	:
Written By	:	Due Date	: 15/12/2005 Qty: 40 Um: Each
Checked & Approved By	:		
Comment	: Est:A 01.07.11 New Issue SM/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Check for cracks while loading into the machine

Machine as per Folio FA153 and Dwg D3041

Tumble and Deburr rough edges after tumbling

Identify as D3041-3

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 24407

Part Number: D30413

Job Number:



Seq. #:	Machine Or Operation:	Description :
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7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

9.0	D2611	Bearing
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10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

13.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

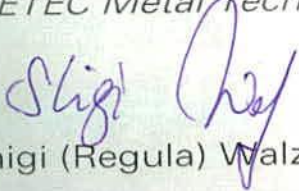
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D 3041-3	Clamp	2008788

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, November 26, 2005

